

Date: Tuesday, 02/12/2008 2:37:59 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PANEL-350 FWD CANOPY
Job Number :	43889		
Estimate Number :	13099		
P.O. Number :		Part Number :	D36563
This Issue :	02/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3656 REV B
First Issue :	//	Project Number :	00204
Previous Run :	42280	Drawing Revision :	B
	Type :	Material :	
	THERMOFORMING	Due Date :	09/12/2008
Written By :		Qty:	1
Checked & Approved By :	<u>MF 08-12-02</u>	Um:	Each
Comment :	Est. Rev. A 07/12/13 New Issue DL verified by:DD Est. Rev. B 08/09/25 Dwg. Update DL		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
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Comment: Qty.: 34.6600 sf(s)/Unit Total : 34.6600 sf(s)

GE PLASTICS LEXAN SHEET

batch: M107574

BB 08/12/02 X 2

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

BB 08/12/02 X 2

3.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. BFolio Rev. A

BB 08/12/02 X 2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 08/12/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-3 PAR #: N/A Fault Category: Prod - THERMO NCR: Yes No DQA: AK Date: 08.12.04
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: AK Date: 08/12/04

NCR: 43889		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/12/03	#30	one part scrap. Part didn't form correctly in during thermforming D.C. haven't received now	<u>BS/11/12</u>	SCRAP and Destroy. no replace	<u>BB</u> <u>08/12/03</u>	<u>S</u> <u>08/12/03</u>	<u>BS/11/12</u>	<u>S</u> <u>8/12/03</u>
		Replacement mold. - TOOLING						

NOTE: Date & initial all entries

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Drawing Name: PANEL-350 FWD CANOPY

Job Number: 43889

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 08/12/03 (X1)

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

BB 08/12/03 (X1)

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 08/12/03 (X1)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BB 08/12/03 (X1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location

PPP 43882

8/12/03

(X1)

Scp

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/03

Job Completion



MF 08-12-03

DART AEROSPACE LTD		Work Order:	43889
Description: Panel		Part Number:	D3656-3
Inspection Dwg: D3656	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition	✓			
Free of visual flaws (bumps, cracks, voids, etc.)	✓			

Measured by: BB Date: 08/12/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.040	Min	.053				
0.045	Min	.074	✓			
0.050	Min	.080	✓			

Measured by: BB Date: 08/12/03
Audited by: 2 Date: 08/12/03
Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DL <u>af</u>	<u>af</u>

